

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020141**Date Inspected:** 21-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Ping (ZPMC)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 13

This QA Inspector observed the following work in progress:

SAW welding of partial joint penetration weld joint(s) located on Tie Down Seat Sub-Assembly identified as SA3011-001 weld number(s) 003. Welder is identified as welder no. 050502. The welding variables recorded by ABF QA identified as Mr. Sheng Quing appeared to comply with applicable WPS(s) WPS-B-T-2221-B-L2C-S-2.

Please see the attached photo

SAW welding of partial joint penetration weld joint(s) located on Tie Down Seat Sub-Assembly identified as SA3011-001 weld number(s) 005. Welder is identified as welder no. 050502. The welding variables recorded by ABF QA identified as Mr. Sheng Quing appeared to comply with applicable WPS(s) WPS-B-T-2221-B-L2C-S-2.

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FCAW welding of partial joint penetration weld joint(s) located on Tie Down Seat Sub-Assembly identified as SA3011-001 weld number(s) 005. Welder is identified as welder no. 067079. The welding variables recorded by ABF QA identified as Mr. Sheng Quing appeared to comply with applicable WPS(s) WPS-B-T-2332-ESAB.

Please see the attached photos

OBG BAY 14

This QA Inspector observed the following work in progress:

SAW welding of complete joint penetration weld joint(s) located on SEG3019M Floor Beam identified as FB3287-001 weld number(s) 032 and 027. Welder is identified as welder no. 044771. The welding variables recorded by ABF QA identified as Mr. Sheng Quing appeared to comply with applicable WPS(s) WPS-B-T-2221-B-L2C-S-2.

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3106-001 weld number(s) 120. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

SMAW welding of complete joint penetration weld joint(s) located on Floor Beam Diaphragm to Deck Plate identified as noted above. Welder is identified as welder no. 054013. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-345-SMAW-2G-(2F)-Repair-FCM

During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3106-001 weld number(s) 102. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

SMAW welding of complete joint penetration weld joint(s) located on Floor Beam Diaphragm to Deck Plate identified as noted above. Welder is identified as welder no. 054013. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-345-SMAW-2G-(2F)-Repair-FCM

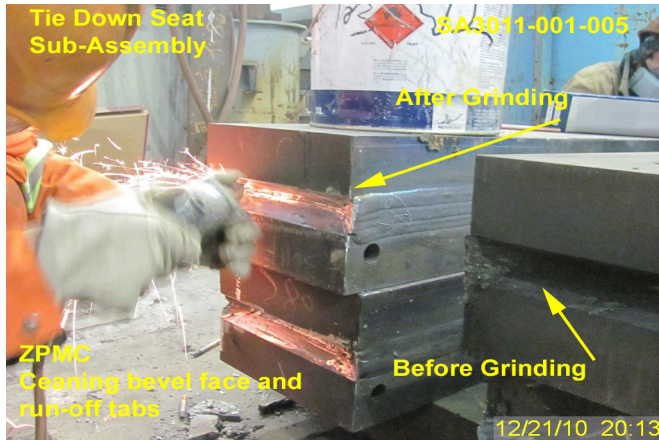
During random in process inspection of Orthotropic Box Girder; (OBG) member identified as DP3106B-001 weld number(s) 042. This QA Inspector observed weld repair of complete joint penetration weld joint(s). ZPMC Quality Control personnel previously tested and rejected portions of this weld.

SMAW welding of complete joint penetration weld joint(s) located on Floor Beam Diaphragm to Deck Plate identified as noted above. Welder is identified as welder no. 068091. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-345-SMAW-2G-(2F)-Repair-FCM

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By: DeArmond, Robert

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer